

Ship Monday 14/06

Work Order ID 59735

June 10, 2010 10:27:32 AM



Page 1

Item ID: D119-647-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 6/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 6/14/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3034

Rev A1

100

0.00



DC

Document Control

DOCUMENT CONTROL

pb ✓

Memo

Photocopy bluefile & type labels per PPP D119-647-011

0.00

CHG 002

S. O. G. 14

ff for BG 10/06/10

160

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

10-6-11 CTD 2

170

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

S. O. G. 14



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Page 2

Item ID: D119-647-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 6/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 6/14/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180 | Packaging | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D119-647-011 Location: _____ PPP Rev: <u>B</u> | | | | | | | | |
| 190 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

Rec'd 6/17 (4)

ME 10-6-17

Picklist Print

June 10, 2010 10:27:30 AM

Page 1

Work Order ID: 59735



Parent Item: D119-647-011



Parent Item Name: Bearpaw

Start Date: 6/10/10

Required Date: 6/14/10

Comments: IPP Rev:A New Issue 07-02-02 JLM
 IPP Rev:B Update Step 7.0 07-07-28 JLM Verified By:EC
 IPP Rev:C Add MFG Eng Step 2 08-04-13 Verified By:EC
 IPP Rev:D New Manufacturing Method 08-11-17 JLM Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

| | | | | | | | |
|----------------|--------------|----|-----|------|----------|------|----------|
| D3034-1 | Manufactured | No | 170 | Each | 0.0000 | 2 | 8 |
| | | | | | | | |
| Bearpaw | | | | | | | |
| D2182B | Manufactured | No | 170 | f | 315.5812 | 2.75 | 11.57895 |
| | | | | | | | |
| Rubber Cushion | | | | | | | |

BS972.6 10-6-11 SP

10-6-11 SP

| Location | Loc Qty | Loc Code |
|----------|----------|----------|
| ST402A | 9.67 | |
| 30872 | 9.67 | |
| ST410 | 305.9112 | |
| 52649 | 305.9112 | |

cut to 5.5" per dwg D2182 (D2182B055) {QTY 6}

| | | | | | | | |
|--------------|--------------|----|-----|------|----------|----|-----|
| D2274 | Manufactured | No | 170 | Each | 639.0000 | 12 | .48 |
| | | | | | | | |
| Radius Block | | | | | | | |

10-6-11 SP

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST010 | 639 | |
| 57714 | 146 | |
| 57912 | 273 | |
| 59108 | 220 | |

48

| | | | | | | | |
|--------|--------------|----|-----|------|----------|----|-----|
| D2529 | Manufactured | No | 170 | Each | 614.0000 | 12 | .48 |
| | | | | | | | |
| Washer | | | | | | | |

10-6-11 SP (40)

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST017 | 614 | |
| 56184 | 14 | |
| 58568 | 600 | |

14
34

Picklist Print

June 10, 2010 10:27:30 AM

Work Order ID: 59735



Parent Item: D119-647-011



Parent Item Name: Bearpaw

Start Date: 6/10/10

Required Date: 6/14/10

Comments: IPP Rev:A New Issue 07-02-02 JLM
 IPP Rev:B Update Step 7.0 07-07-28 JLM Verified By:EC
 IPP Rev:C Add MFG Eng Step 2 08-04-13 Verified By:EC
 IPP Rev:D New Manufacturing Method 08-11-17 JLM Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

D2947 Manufactured No 170 Each 116.0000 6 24



Clamp



10-6-11 SP

Location Loc Qty Loc Code

ST457 116

55756 116

AN4-15A Purchased No 170 Each 363.0000 12 48



Bolt



20
10-6-11 SP

Location Loc Qty Loc Code

ST358 363

114239 3

114292 60

114615 100

114784 200

AN960JD416 NAS1149D0463J Purchased No 170 Each 18.0000 12 48



Washer



1114576 10-6-11 SP

Location Loc Qty Loc Code

ST357 18

107939 18

Picklist Print

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Parent Item Name: Bearpaw

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Comments: IPP Rev:A New Issue 07-02-02 JLM
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 IPP Rev:D New Manufacturing Method 08-11-17 JLM Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

170

Each

3,833.000

12

48



Nut



10.6.11 SL (40)

Location

Loc Qty

Loc Code

ST139

2

111827

2

ST300

3831

113422

68

114523

755

114718

1000

114784

2000

9063

8

98

5. Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4-15A bolts with longer or shorter AN4 bolts, if required.
6. Lower the aircraft

32.2 BEARPAW REMOVAL

1. Jack up the aircraft.
2. Loosen the clamp bolts and remove the bearpaws and clamps. Ensure the skid tubes are serviceable.
3. Lower the aircraft.

32.3 WEIGHT AND BALANCE

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|--|--------------------|-----------------|-----------------------|--------------------|-------------------------|
| | | Arm | Moment | Arm | Moment |
| D119-647-011 Bearpaw Installation on model A119 aircraft | 15.4 lb 7.00 kg | 0.0 in 0.0 m | 0.0 lb-kg 0.0 m-kg | 173.2 in 4.40 m | 2667 in-lb 30.8 m-kg |

32.4 PARTS LIST

| Qty | Part Number | Description |
|-----|--------------|----------------------|
| X | D119-647-011 | BEARPAW INSTALLATION |
| 6 | D2182B055 | RUBBER CUSHION |
| 12 | D2274 | RADIUS BLOCK |
| 2 | D3034-1 | BEARPAW |
| 12 | D2529 | WASHER |
| 6 | D2947 | CLAMP |
| 12 | AN4-15A | BOLT |
| 12 | AN960JD416 | WASHERS |
| 12 | MS21042L4 | NUT (OR MS21042-4) |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries